

Work Order ID 162097

Thursday, May 25, 2017 11:18:46 AM

162097

Page 1

Item ID: D5162-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Structure Assembly

Start Date: 5/25/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/9/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3016	(DEO) A1
D3017	C
D5162	A
D5189	A

105	Pick Kit	0.00
-----	----------	------

105

Packaging

Memo

0.30

Packaging

110	Weld per dwg A/R 4130 rod Batch: <u>127925</u>	0.00
-----	--	------

110

Large Fab

Memo

1.00

Large Fab

FABRICATE D5189-041 AS PER DWG AND BY USING DT8622.

DO NOT OPEN HOLES TO SIZE, IT WILL BE OPEN UPON FINAL ASSEMBLY.

ONLY WELD STUD D4667-041 TO TUBE. END CAP WILL BE WELDED AFTER OPENING HOLES IN TUBE.

①

DYC

17/06/01

Work Order ID 162097

Thursday, May 25, 2017 11:18:46 AM

162097

Page 2

Item ID: D5162-041 Accept: ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Structure Assembly
Start Date: 5/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/9/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Weld per dwg A/R 4130 rod Batch: <u>27925</u>	0.00							
120									
Large Fab	Memo	1.00							
Large Fab	FABRICATE (2) D3016-041 AS PER DWG.								
	WELD ASSEMBLY USING DT8597 WELD JIG.								
	DO NOT DRILL HOLES AS THEY WILL BE TRANSFER DRILL AT FUTHER STEP.								
	DO NOT WELD GUSSETS AND BRACKET THEY WILL BE WELDED AT A FUTHER STEP.								

① DYC
17/06/17

Work Order ID 162097

Thursday, May 25, 2017 11:18:46 AM

162097

Page 3

Item ID: D5162-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Structure Assembly
Start Date: 5/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/9/2017 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab	Weld per dwg A/R 4130 rod Batch: <u>127425</u>	0.00				(1)		DYC	
Large Fab	Memo FABRICATE D3017-041 AS PER DWG: USE DT8598 FOR BENDING D3017-1/-3 TUBE. USE DT8621 FOR DRILLING (#30 DRILL) BACK FRAME. ***DO NOT OPEN HOLES IT WILL BE DONE AT FUTHER STEP*** USE DT8622 FOR DRILLING (#30 DRILL) D3017-5. ***DO NOT OPEN HOLES IT WILL BE DONE AT FUTHER STEP*** USE DT8598 JIG FOR WELDING TUBES, LUGS AND ONE END CAP, OTHER END CAP WILL BE WELDED AFTER OPENING HOLES.	1.00						17/06/01	
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.02				(1)		17-06-03	PD

Work Order ID 162097

Thursday, May 25, 2017 11:18:46 AM

162097

Page 4

Item ID: D5162-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Structure Assembly
Start Date: 5/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/9/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Large Fab

Large Fab

Memo

1.00

1- BOLT SEAT FRAME TO ASSEMBLY PLATE DT8624.

2- TRANSFER DRILL D5189-041 TO D3016-041 AS PER DWG USING #30
DRILL AND CLECO THEN DRILL TO FINISH SIZE.

3- TRANSFER DRILL SEAT PAN TO D5189-041 AND 3016-041.

4- TRASFER DRILL SEAT AND D3016-041 TO D3017-041 USING
DT _____ AND USING TOOL TO ACHIEVE DESIRED ANGLE ON
BACK REST.

①

DYC

17/06/01

155

Weld per dwg A/R 4130 rod Batch: **27125** 0.00***155***

Large Fab

Large Fab

Memo

1.00

ARMREST:1- ASSEMBLE AND TRANSFER DRILL D5189-043 TO D3017-041.
OPEN HOLES TO FINISH SIZE AS PER DWG**STRUT:**

1-

SEAT BRACE:1- USE DT10132 AND DT10133 TO TRANSFER DRILL HOLES IN SEAT
PAN AND SEAT BRACE.

①

DYC

17/06/01

Thursday, May 25, 2017 11:18:46 AM

Page 5

Quality Control

Work Order ID 162097

Thursday, May 25, 2017 11:18:46 AM

162097

Page 6

Item ID: D5162-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Structure Assembly
Start Date: 5/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/9/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

175

QC5- Inspect part completeness to step on W/O

0.00

175

QC

Memo

0.02

Quality Control

0 17.0605 PD

180

Chemical Conversion Coat per QSI005 4.1

0.00

180

HandFinish

Memo

0.91

Hand Finishing

CHEMICAL CONVERSION SEAT PANEL D3022-1 AND BACK PANEL
D3023-1 AS PER DWG

(X1) 2017/06/06
BET

190

QC7-Inspect Chemical Conversion Coat

0.00

190

QC

Memo

0.02

Quality Control

1X 17/06/07
DAS 36 3-89

Work Order ID 162097

Thursday, May 25, 2017 11:18:46 AM

162097

Page 8

Item ID: D5162-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Structure Assembly
Start Date: 5/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/9/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 36 9-89
230 *230* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.02				1X			17/06/16	
240 *240* Small Fab Small Fab	 Memo ASSEMBLE AS PER DWG	0.00 1.46				1X			17/06/16	DAS 36 9-89
250 *250* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02					1			DAS 30 9-89 JUN 9 2017

Work Order ID 162097

162097

Page 9

Thursday, May 25, 2017 11:18:46 AM

Item ID: D5162-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Structure Assembly
 Start Date: 5/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/9/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: <u>GA</u>	0.00			DAS				
260					30	<u>1</u>			JUN 16 2017
Packaging	Memo	0.01			9-89				
Packaging									
270	QC21- Final Inspection - Work Order Release	0.00							
270									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89

JUN 16 2017

Picklist Print

Thursday, May 25, 2017 11:18:43 AM

Page 1

Work Order ID: 162097

162097

Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.11.05 NEW ISSUE DD VERF:JLM IPP
REV:B 15-02-06 AS PER DWG REV.A DD VERF:JLMIPP REV:C
16.08.31 ADD D3016 PARTS DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3016-1 *D3016-1* Tube		Manufactured	No			105	Each	2.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA001				2					
				160553				2		2			
D3016-11 *D3016-11* Saddle		Manufactured	No			105	Each	4.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA001				4					
				160554				4		2			
D3016-3 *D3016-3* Tube		Manufactured	No			105	Each	4.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA001				4					
				154488				1		1			
				160556				3		3			
D3016-5 *D3016-5* Tube		Manufactured	No			105	Each	2.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA001				2					
				60555				2		2			

** DYC 17/05/31

** DYC 17/05/31

** DYC 17/05/31

** DYC 17/05/31

Picklist Print

Thursday, May 25, 2017 11:18:43 AM

Page 2

Work Order ID: 162097

162097

Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

D3016-7

Manufactured No

105

Each

4.0000

4

4

D3016-7

Tube

**

DYC 17/05/31

LocationLoc QtyLoc Code

WA001

4

(154490)

4

4

D3016-9

Manufactured No

105

Each

4.0000

2

2

D3016-9

Saddle

**

DYC 17/05/31

LocationLoc QtyLoc Code

WA001

4

(160557)

4

2

D5190-1

Manufactured No

110

Each

7.0000

1

1

D5190-1

Armrest Fitting

**

DYC 17/05/30

LocationLoc QtyLoc Code

ST156

6

160621

6

WA003

1

(152308)

1

1

D5190-3

Manufactured No

110

Each

19.0000

1

1

D5190-3

Weld Pin

**

DYC 17/05/29

LocationLoc QtyLoc Code

WA002

19

(154143)

19

1

Thursday, May 25, 2017 11:18:43 AM

Shop Packet Print

Page 2

Picklist Print

Thursday, May 25, 2017 11:18:43 AM

Page 3

Work Order ID: 162097

162097

Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

M4130NT0.750W.049

Purchased

No

105

f

59.0190

13.8

14.52632

M4130NT0 750W 049

4130 RD Tube .750 x.049W

**

DYC 17/05/29

Location

Loc Qty

Loc Code

MAT033

59.019

m136760

15.168

m137091

2.767

m137286

12.1

m137415

10.317

m137477

18.667

~~6,133~~

2,333

9,333

D4667-041

Manufactured

No

110

Each

2.0000

1

1

D4667-041

Armrest Stud Assembly

**

DYC 17/05/29

Location

Loc Qty

Loc Code

WA001

2

154903

2

1

D3020-1

Manufactured

No

120

Each

0.0000

4

4

D3020-1

Fitting

D3017-7

Manufactured

No

130

Each

6.0000

3

3

D3017-7

Lug

**

DYC 17/05/29

Location

Loc Qty

Loc Code

WA002

6

155291

3

156836

3

3

Thursday, May 25, 2017 11:18:44 AM

Shop Packet Print

Page 3

Picklist Print

Thursday, May 25, 2017 11:18:44 AM

Page 4

Work Order ID: 162097

162097

Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

D3023-1 Manufactured No

130 Each 1.0000 1 1

D3023-1

Back Panel

**

DYC 17/05/30

Location

Loc Qty

Loc Code

WA001

1

159080

1

M4130NT0.750W.083 Purchased No

105 f 29.8560 2.5

M4130NT0 750W 083

4130 RD Tube .750 x.083W

**

DYC 17/05/29

2.631579

Location

Loc Qty

Loc Code

MAT032

29.856

m136569

9.523

m137415

20.333

2,479

D3022-1 Manufactured No

150 Each 1.0000 1 1

D3022-1

Seat Pan

**

DYC 17/05/31

Location

Loc Qty

Loc Code

WA001

1

155302

1

D3016-15 Manufactured No

165 Each 6.0000 2 2

D3016-15

Gusset

**

DYC 17/05/31

Location

Loc Qty

Loc Code

WA002

6

158223

2

158746

4

2

D3016-13 Manufactured No

165 Each 0.0000 2 2

D3016-13

Bracket

**

DYC 17/05/31

B162104 2X

Thursday, May 25, 2017 11:18:44 AM

Shop Packet Print

Page 4

Picklist Print

Thursday, May 25, 2017 11:18:44 AM

Work Order ID: 162097

162097

Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

D3016-17 Manufactured No

165 Each 8.0000 2 2

D3016-17

Gusset

**

DYC 17105131

Location

Loc Qty

Loc Code

WA002

8

138268

2

158751

6

D3017-11 Manufactured No

165 Each 9.0000 4 4

D3017-11

Cap

**

DYC 17105129

Location

Loc Qty

Loc Code

WA001

9

156769

9

MS20600-AD4W2 Purchased No

200 Each 286.0000 46

MS20600-AD4W2

Rivet

**

25

4640

17/06/07

DAS
36
9-89

Location

Loc Qty

Loc Code

CCK004

125

m137075

125

GA

44

m126475

6

m136047

1

m136579

37

ST308

117

m134762

17

m137459

100

4

36

88-6
36
DAS

* MS20600-AD4W3

6x

129795

17/06/07

DAS
36
9-89

Picklist Print

Page 7

Thursday, May 25, 2017 11:18:44 AM

Work Order ID: 162097

162097

Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-20

Purchased

No

240

Each

68.0000

4

4

MS27039-4-20

Screw

**

JUN 15 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

ST279

68

~~m135056~~

18

m137321

50

MS20600-AD4W4

Purchased

No

240

Each

2,018.0000

4

4

MS20600-AD4W4

Rivet

**

JUN 15 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

CCK004

1511

M135704

11

M137412

1000

M137587

500

ST308

42

M137075

42

WA003

465

M135442

204

M136986

108

M137075

153

MS27039-1-19

Purchased

No

240

Each

439.0000

4

4

MS27039-1-19

Screw

**

JUN 15 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

80

m134134

80

over006

300

m137361

300

ST280

59

m137075

59

Thursday, May 25, 2017 11:18:44 AM

Shop Packet Print

Page 7

Picklist Print

Thursday, May 25, 2017 11:18:44 AM

Page 10

Work Order ID: 162097

162097

Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

D5159-041

Manufactured No

105

Each

3.0000

1

1

D5159-041

Seat Back Brace Assembly

**

DYC 17/06/01

Location

Loc Qty

Loc Code

ST358

3

159070

2

160485

1

AN4-14A

Purchased No

240

Each

440.0000

2

2

AN4-14A

Bolt

**

JUN 15 2017

DAS
6
9-8g

Location

Loc Qty

Loc Code

FG

5

122141

5

over003

200

M136554

0

M137495

100

M137544

100

ST344

235

M137371

235

D3031-1

Manufactured No

240

Each

10.0000

2

2

D3031-1

Loop

**

JUN 15 2017

DAS
6
9-8g

Location

Loc Qty

Loc Code

GA

10

159132

10

AN3-12A

Purchased No

240

Each

197.0000

3

3

AN3-12A

Bolt

**

JUN 15 2017

DAS
6
9-8g

Location

Loc Qty

Loc Code

ST349

197

153854

197

Thursday, May 25, 2017 11:18:45 AM

Shop Packet Print

Page 10

Picklist Print

Thursday, May 25, 2017 11:18:45 AM

Page 11

Work Order ID: 162097

Parent Item: D5162-041

Parent Item Name: Seat Structure Assembly

162097

D5162-041

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

240

Each

2,912.000

8

8

MS21042L 4

Nut

**

JUN 15 2017

DAS
6
9-8

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

64

m135058

64

OVER007

1400

m137402

400

m137544

1000

ST303

1438

m137321

438

m137371

1000

D2199-31

Manufactured

No

105

Each

7.0000

1

1

D2199-31

Strut Details

**

DYK 17/06/01

Location

Loc Qty

Loc Code

ST352

7

158213

7

MS27039-1-20

Purchased

No

240

Each

73.0000

2

2

MS27039-1-20

Screw

**

JUN 15 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST280

73

m136554

73

Picklist Print

Thursday, May 25, 2017 11:18:45 AM

Page 12

Work Order ID: 162097

162097

Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 5/25/2017

Required Date: 6/9/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-21

Purchased

No

240

Each

55.0000

2

2

MS27039-4-21

Screw

**

JUN 15 2017

DAS

6

9-1

Location

Loc Qty

Loc Code

ST279

55

m135774

55

2

MS27039-1-18

Purchased

No

240

Each

1,615.000

3

3

MS27039-1-18

Screw

**

JUN 15 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

239

123522

39

124326

200

over006

1200

124326

1200

ST280

176

124326

176

3

D5159-045

Manufactured

No

105

Each

3.0000

1

1

D5159-045

Seat Rib Assembly

**

DYC 17/06/1

Location

Loc Qty

Loc Code

ST358

3

160558

3

1

AN970-4

Purchased

No

240

Each

158.0000

1

1

AN970-4

Washer

**

JUN 15 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

OVER007

50

m137544

50

ST321

108

m137321

108

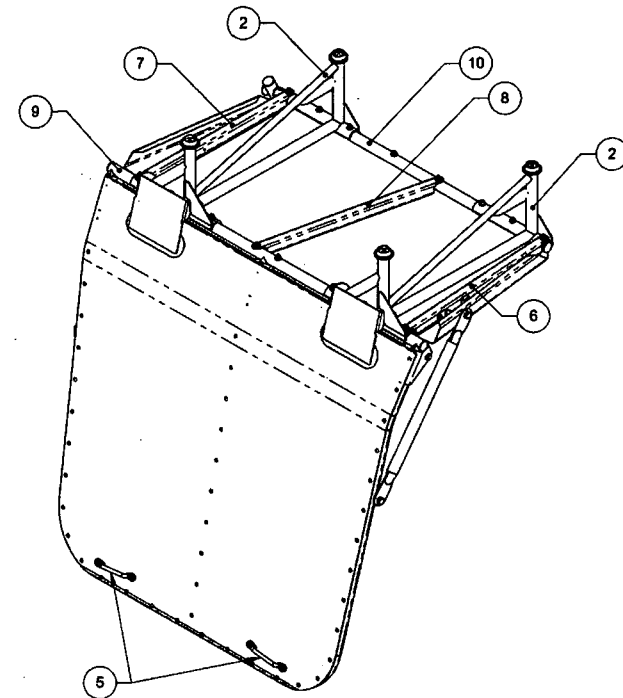
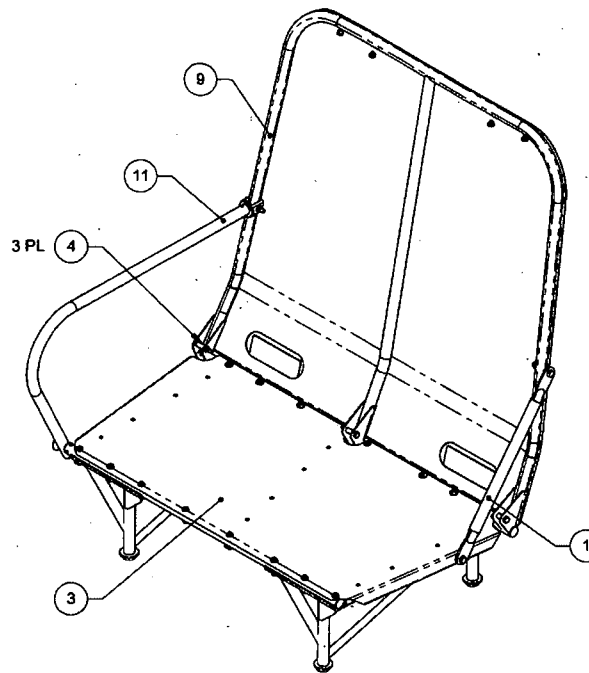
1

Thursday, May 25, 2017 11:18:45 AM

Shop Packet Print

Page 12

ITEM	QTY	P/N	DESCRIPTION
	X	D5162-041	SEAT STRUCTURE ASSEMBLY
1	1	D2199-31	STRUT
2	2	D3016-041	SEAT FRAME ASSEMBLY
3	1	D3022-1	SEAT PAN
4	3	D3024-1	SPACER
5	2	D3031-1	LOOP
6	1	D5159-041	SEAT BACK BRACE ASSY
7	1	D5159-043	SEAT BACK BRACE ASSY
8	1	D5159-045	SEAT RIB ASSY
9	1	D5162-051	SEATBACK ASSEMBLY
10	1	D5189-041	TUBE ASSEMBLY
11	1	D5189-043	ARMREST ASSEMBLY
12	3	AN3-12A	BOLT
13	1	AN4-6A	BOLT
14	1	AN4-4A	BOLT
15	2	AN4-14A	BOLT
16	1	AN970-4	WASHER
17	4	MS20800AD4W4	RIVET, BLIND
18	8	MS20600AD4W5	RIVET, BLIND
19	17	MS21042L3	NUT, SELF-LOCKING
20	8	MS21042L4	NUT, SELF-LOCKING
21	4	MS24693-S49	SCREW, CSK 100°
22	1	MS27039-1-17	SCREW, PAN-HEAD
23	3	MS27039-1-18	SCREW, PAN-HEAD
24	4	MS27039-1-19	SCREW, PAN-HEAD
25	2	MS27039-1-20	SCREW, PAN-HEAD
26	2	MS27039-4-21	SCREW, PAN-HEAD
27	4	MS27039-4-20	SCREW, PAN-HEAD
28	17	NAS1149D0432J	WASHER
29	30	NAS1149D0332J	WASHER
30	2	NAS43DD4-16FC	SPACER



D5162-041 SEAT STRUCTURE ASSEMBLY

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 19.1 lbs

RELEASED

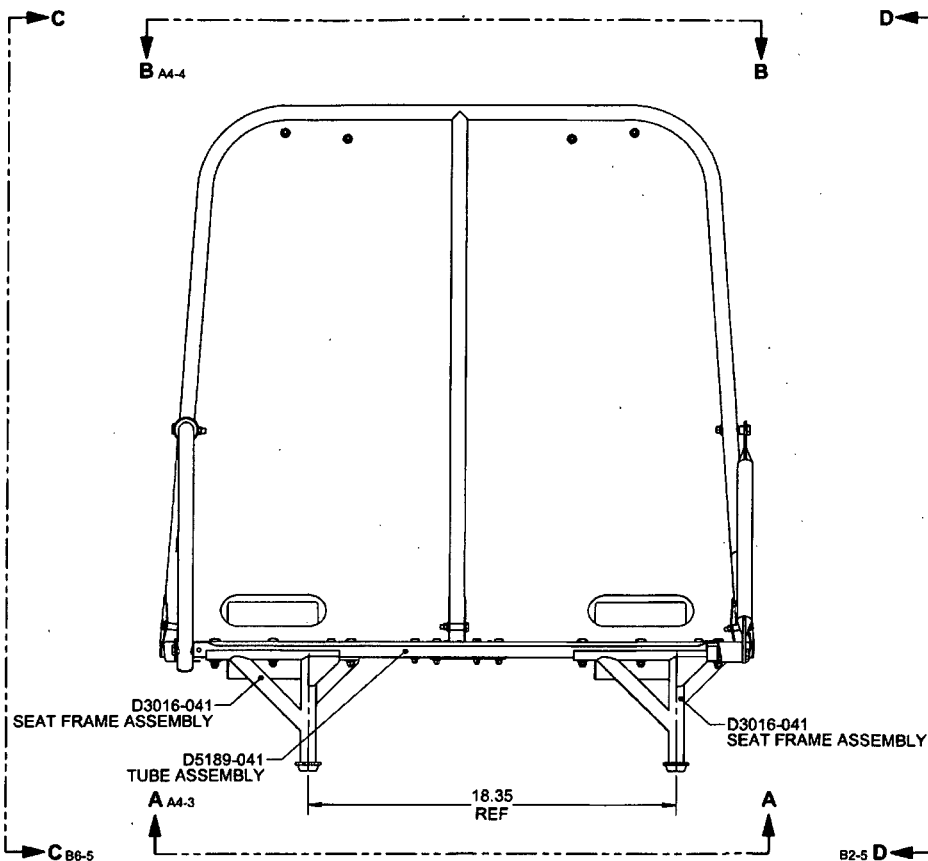
2015 FEB 04

ECN 15-522 4

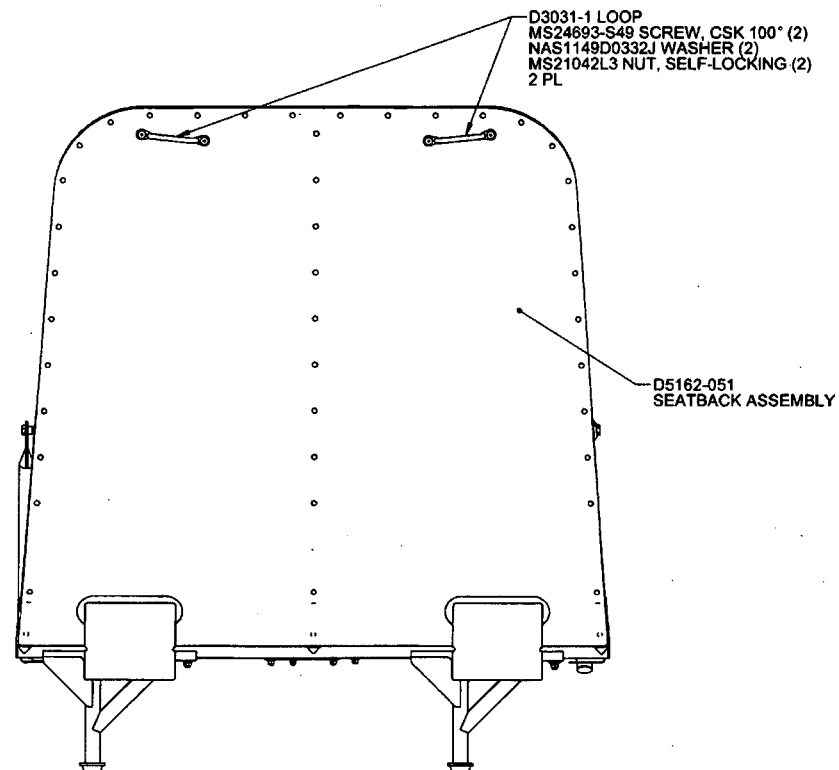
APPROVED

A	NEW ISSUE	AJS	14.10.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	14.10.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D5162	REV. A SHEET 1 OF 6
TITLE SEAT STRUCTURE ASSY	SCALE NTS
COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



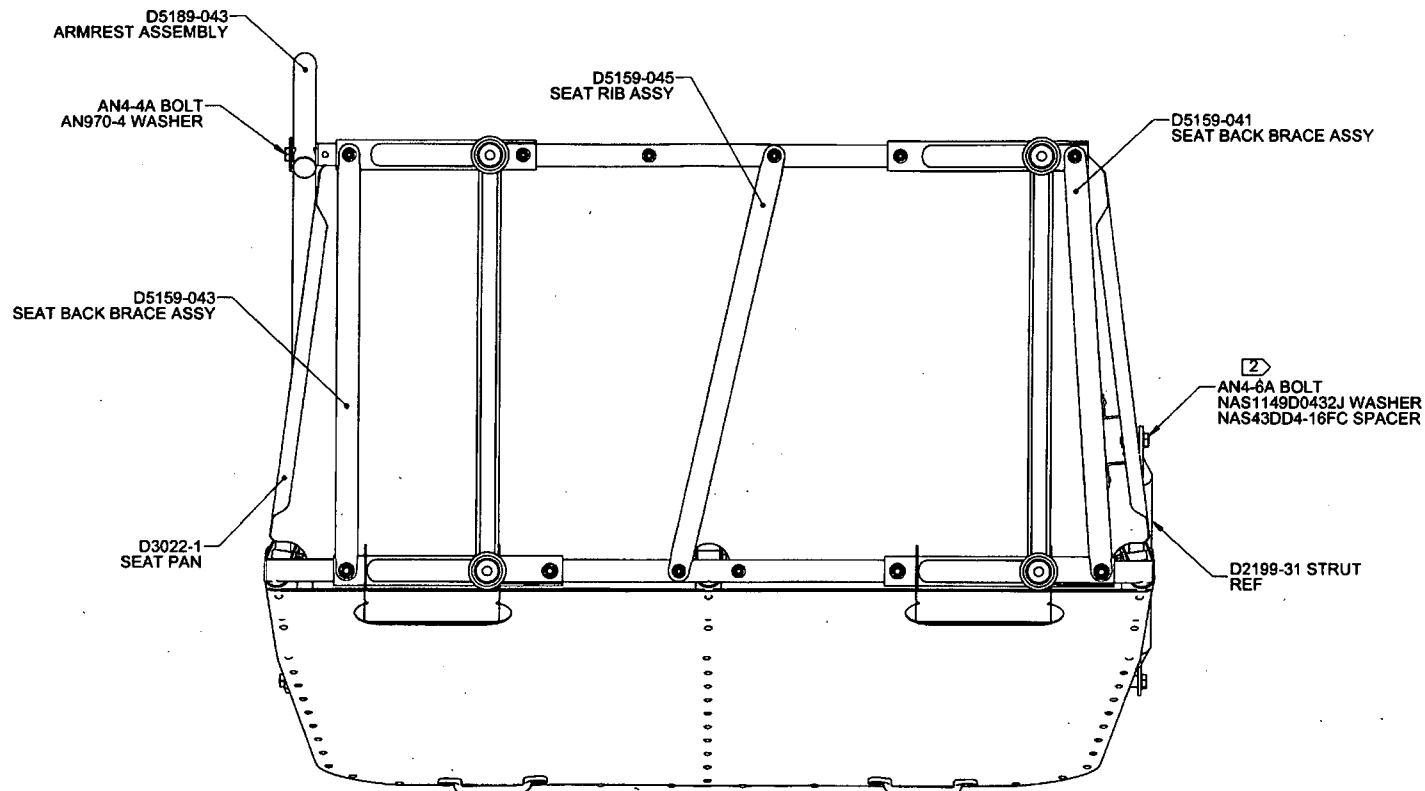
D5162-041 SEAT STRUCTURE ASSEMBLY



RELEASED
2015 FEB 04

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5162	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SEAT STRUCTURE ASSY	NTS
DATE	14.10.03	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE, AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



VIEW A-A B8-2
(SCALE 1.5X)

RELEASED

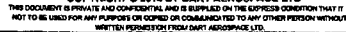
2015 FEB 04

SHEET 3 NOTES:

- 1) INSTALL D2199-31 STRUT AT SEAT PAN END FIRST
- 2) TRANSFER MARK FROM D5159-041 SEAT BACK BRACE ASSY TO D3022-1 SEAT PAN AND DRILL $\varnothing 0.386$ THRU D3022-1 SEAT PAN.

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5162	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SEAT STRUCTURE ASSY	NTS
DATE	14.10.03	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



5

MS27039-4-20 SCREW, PAN-HEAD
(2) NAS1149D0332J WASHER
MS21042L4 NUT, SELF-LOCKING

D5159-043
SEAT BACK BRACE ASSY
REF

MS20600AD4W5
RIVET, BLIND, 4 PL
(INTO D5159-043)

MS27039-1-20 SCREW, PAN-HEAD
(2) NAS1149D0332J WASHER
MS21042L3 NUT, SELF-LOCKING

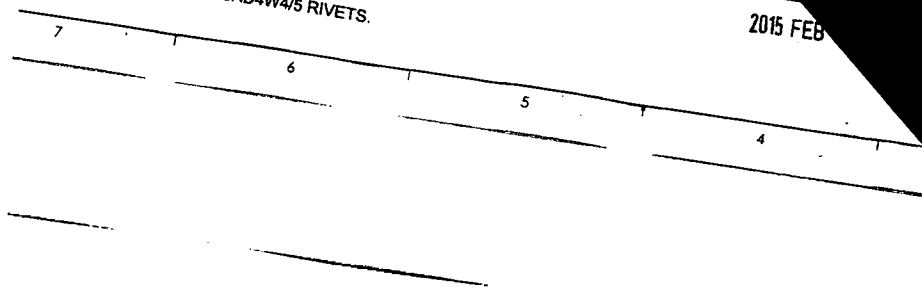
MS27039-1-19 SCREW, PAN-HEAD
(2) NAS1149D0332J WASHER
MS21042L3 NUT, SELF-LOCKING

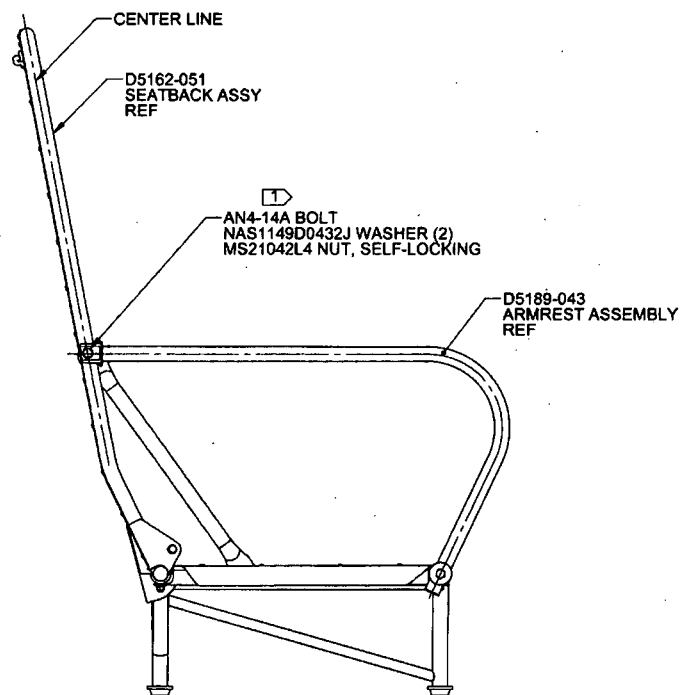
MS27039-1-17 SCREW, PAN-HEAD
(2) NAS1149D0332J WASHER
MS21042L3 NUT, SELF-LOCKING

VIEW
(SCALE 1/2)

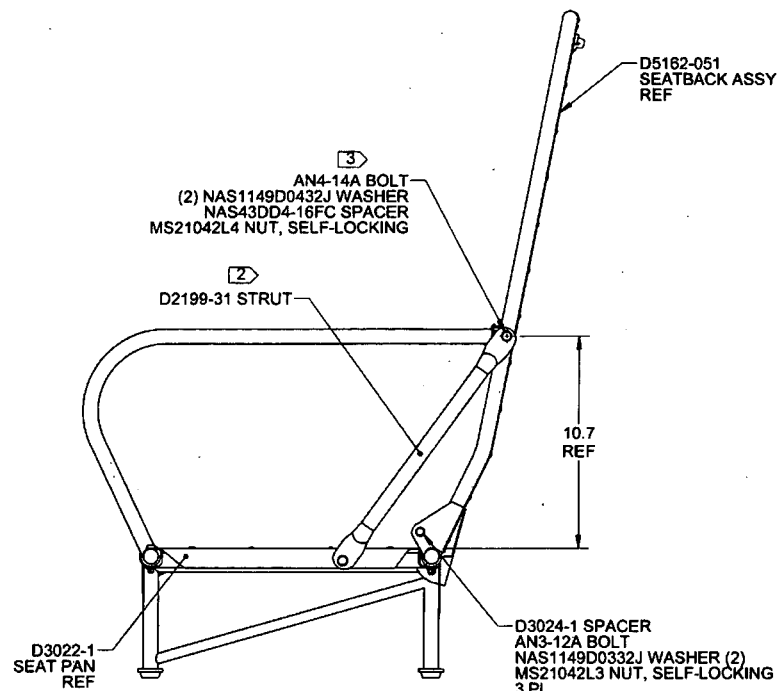
39-041/-043/-045 TO D3022-1 SEAT PAN
N THEN INSTALL MS20600AD4W4/5 RIVETS.

RELEASE
2015 FEB





VIEW C-C A8-2



VIEW D-D A5-2

SHEET 2 NOTES:

- 1) ALIGN THE PILOT HOLE ON THE D5189-043 ARMREST ASSEMBLY TO THE CENTERLINE ON THE D5162-051 BACK FRAME ASSEMBLY AND DRILL $\varnothing 0.257$ THRU THE D5189-043 AND D5162-051.
- 2) INSTALL D2199-31 STRUT AT SEAT PAN END FIRST
- 3) TRANSFER MARK FROM D2199-31 STRUT TO D5162-051 SEATBACK ASSY AND DRILL $\varnothing 0.266$ THRU D5162-051 SEATBACK ASSY

RELEASED
2015 FEB 04

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5162	SHEET 5 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SEAT STRUCTURE ASSY	NTS
DATE	14.10.03	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -051	P/N	DESCRIPTION
	X	D5162-051	SEATBACK ASSEMBLY
1	1	D3017-041	BACK FRAME ASSEMBLY
2	1	D3023-1	BACK PANEL
3	46	MS20600AD4W2	RIVET, BLIND

D3017-041
BACK FRAME ASSEMBLY

MS20600AD4W2
RIVET, BLIND
46 PL

D3023-1
BACK PANEL

8 D5162-051 SEATBACK ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.42 lbs
- 8) TRANSFER MARK FROM D3023-1 TO D3017-041.
DRILL $\varnothing 0.129$ INTO THE D3017-041 (DRILL THRU ONE WALL ONLY).
THEN INSTALL MS20600AD4W2 RIVETS.

RELEASED
2015 FEB 04

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5162	SHEET 6 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SEAT STRUCTURE ASSY	NTS
DATE	14.10.03	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	